

Page 8, line 16, delete "slot", and insert --slit--, and, after "is", insert --not--;

Page 10, last line, delete "vertically" and insert --angularly--; and

Page 15, line 14, delete "and", and insert --an--.

IN THE CLAIMS

Please cancel claims 1 through 13.

Please add the claims 18 through 40:

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18. The method of claim 14, wherein said perforations that are formed are slits that have a width about 0.040 to about 0.080 inches.

19. The method of claim 18, wherein said slits have a width about 0.058 to about 0.062 inches.

A2
20. The method of claim 19, wherein said slits have a width about 0.060 inch.

21. The method of claim 18, wherein said forming step is effected by piercing said domed portion of said vent disc with blades that have an elongated cutting edge formed by angular surfaces.

22. The method of claim 21, wherein said angular surfaces

are disposed at an angle of about 40 degrees.

23. The method of claim 21, wherein said forming step is effected by driving said blades completely through said domed portion of said vent disc.

24. The method of claim 16, wherein said perforations that are formed are slits that have a width about 0.040 to about 0.080 inches.

25. The method of claim 24, wherein said slits have a width about 0.058 to about 0.062 inches.

26. The method of claim 25, wherein said slits have a width about 0.060 inch.

27. The method of claim 24, wherein said forming step is effected by piercing said domed portion of said vent disc with blades that have an elongated cutting edge formed by angular surfaces.

28. The method of claim 27, wherein said angular surfaces are disposed at an angle of about 40 degrees.

29. The method of claim 27, wherein said forming step is effected by driving said blades completely through said residual of said domed portion of said vent disc.

30. The apparatus of claim 17, wherein said means for mounting said plurality of piercing means includes a mandrel having a convex arcuate upper surface with a radii of curvature that corresponds to said radii of curvature that form said domed

portion of said vent disc.

31. The apparatus of claim 30, wherein each of said plurality of piercing means has a base, and wherein said base rests on said arcuate upper surface of said means for mounting.

32. The apparatus of claim 30, wherein said means for mounting said plurality of piercing means includes a piercing die that is disposed above said mandrel and that has a plurality of elongated slots that extend therethrough for receiving said piercing means, said slots having their longitudinal axes disposed along said radii of curvature that form said arcuate upper surface of said mounting means and along said radii of curvature that form said concavely domed portion of said vent disc.

A2
33. The apparatus of claim 32, wherein said driving means drives said means for mounting with said piercing means mounted thereon such that said piercing means are received in said plurality of elongated slots.

34. The apparatus of claim 32, wherein said piercing die has a convex upper surface with a radii of curvature that corresponds to said radii of curvature of said concavely domed portion of said vent disc.

35. The apparatus of claim 17, wherein said apparatus includes a backstop, said backstop having an undersurface that is convex and has a radii of curvature that corresponds to said concavely curved domed portion of said central panel.

36. The apparatus of claim 35, wherein said means for

mounting said plurality of piercing means includes a piercing die that is disposed above said mandrel and that has a plurality of elongated slots that extend therethrough for receiving said piercing means, and wherein said holding means includes said undersurface of said backstop and said undersurface has a plurality of relieves formed therein that are radially aligned with said slots in said piercing die.

37. A method of forming a vent disc having a concavely domed central panel, comprising:

providing vertically reciprocable piercing elements;

providing a vent disc having a concavely domed central panel that is formed by radii of curvature;

A2 temporarily flattening said domed central panel;

disposing said piercing elements such that they are perpendicular to said temporarily flattened domed central panel;

perforating said temporarily flattened domed central panel by use of said vertically reciprocable piercing elements;

removing said piercing elements from said temporarily flattened domed central panel; and

terminating said flattening step to allow said central panel to return to its domed configuration.

38. The method of claim 37, wherein said perforating step is effected by driving a portion of each of said piercing